

Date: Friday, 7/4/2008 12:50:10 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 40300 -2
 Estimate Number : 12883
 P.O. Number :
 This Issue : 7/4/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : MACHINED PARTS
 Previous Run : 35405

Drawing Name : ARM

Part Number : D3560043
 Drawing Number : D3560 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 7/14/2008

Written By :
 Checked & Approved By :
 Comment :
 Est Rev: A New Issue 07.05.24 EC
 Est Rev B ECN 987 07.10.09 EC
 Est Rev: C ECN1048 07-12-18 DD verified by: EC

Qty: Um: Each

Additional Product

Job Number:



was alone?

Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.3598 f(s)/Unit Total : 5.4390 f(s)
 6061-T6 Bar 0.50" x 5.00"
 Batch: M108586

H.A

08/07/16

8

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks 15.500" long

H.A

08/07/16

8

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: B & Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

SD / H.A

08/07/19

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD / H.A

08/07/19

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 40300

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

PLATE

B 35331-5

B35921-34 B41083-3

08.08.29

8

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) SP
- 2- set up bracket and arm on jig SP
- 3- preheat bracket and arm with torch SP
- 4- clean before welding with brush SP
- 5- set up machine to 135 amps SP
- 6- weld across bottom and top ends SP
- 7- reheat with torch (65 deg C) SP
- 8- on one side weld from bottom to top half way SP
- 9- same for other side (half way) SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP
- 11- same for remaining side (ease off pedal near end) SP

P10

08.09.02

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08.09.05

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 08-09-05

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HJ

08-09-08 24

1871

1871

1871

1871

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 40300

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-a 08/09/08 (4X)

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

batch: *B37113*

E 08/09/08

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

E 08/09/08 (4)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/08 (4C)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

fat 2

S 08/09/08 (4C)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/09

Job Completion



mf 08-09-09

RELEASED
07.12.16

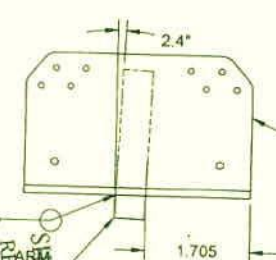
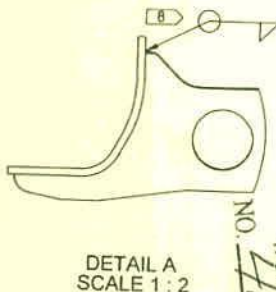
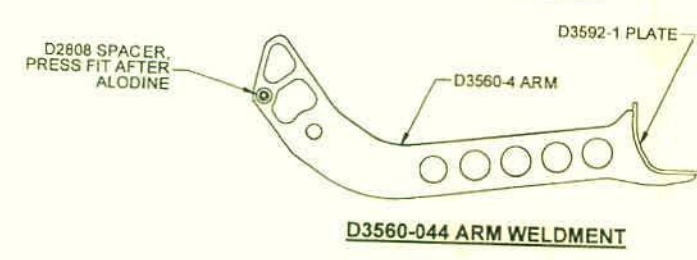
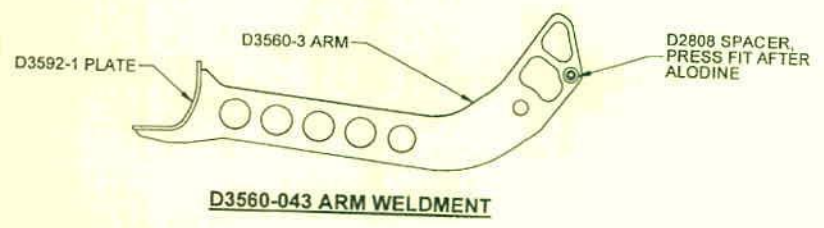
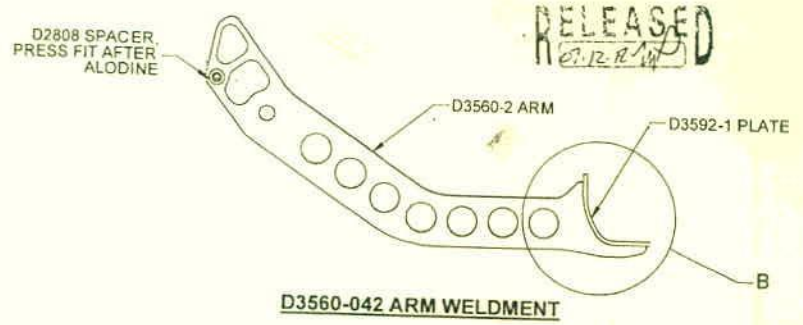
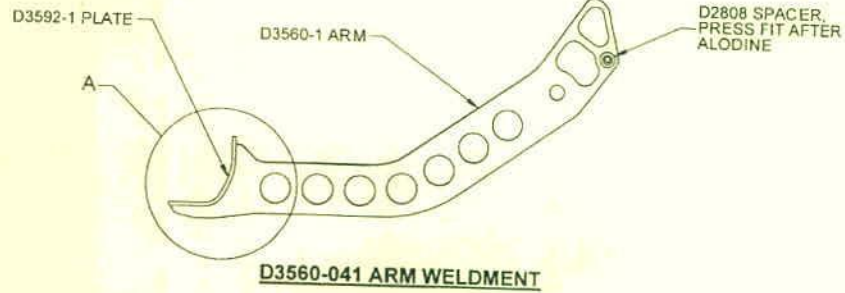
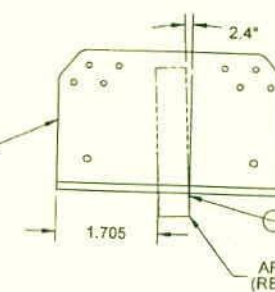
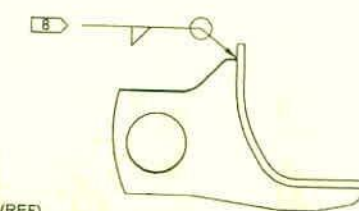


PLATE (REF)



ARM (REF)



PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

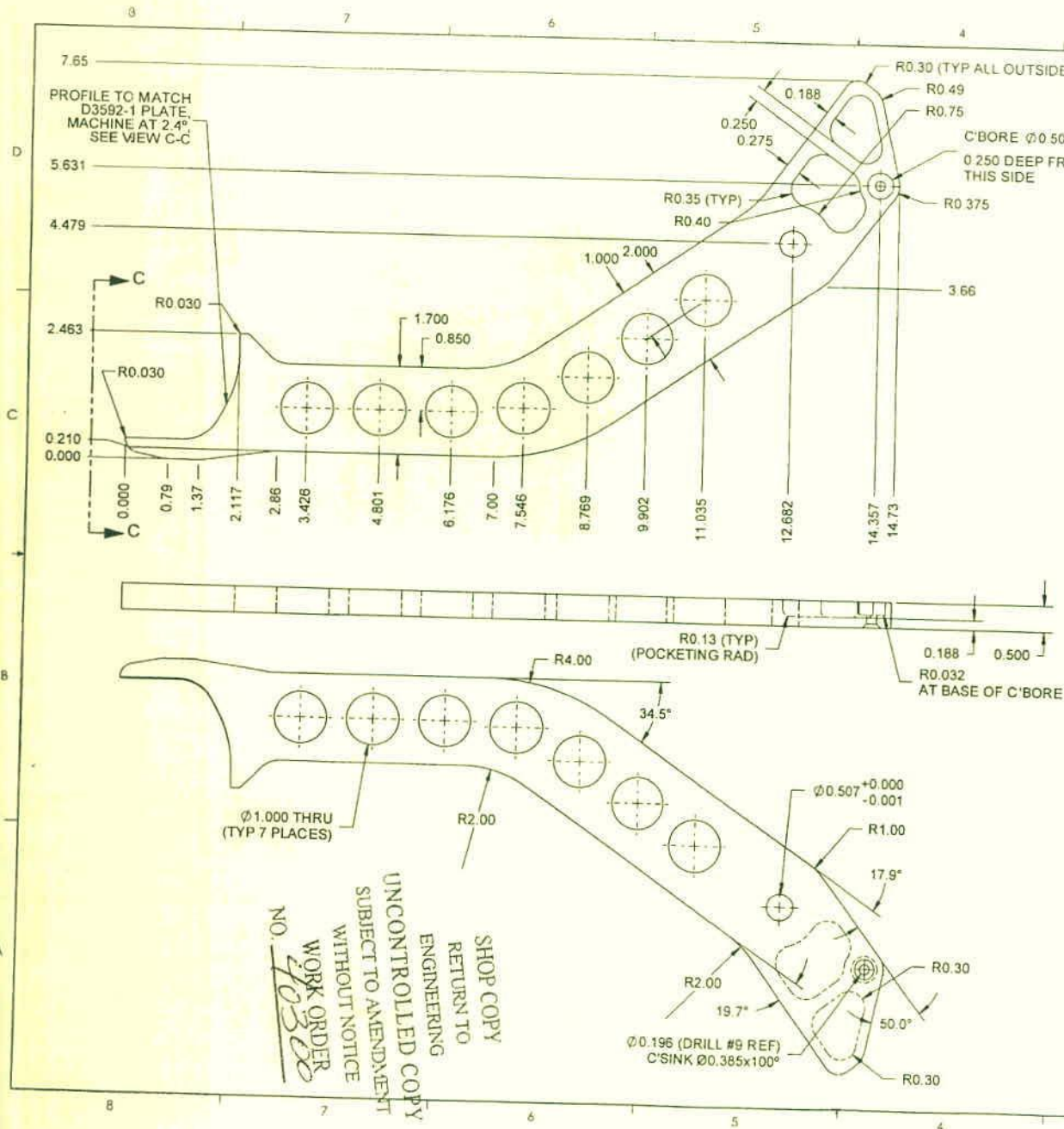
DESIGN	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	REMOVE POWDER COAT	CP	07.06.19
CHECKED	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
MFG. APPR.	NEW ISSUE	CP	06.09.25
APPROVED			
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3560	REV. 0 SHEET 1 OF 5
TITLE ARM WELDMENT	SCALE 1:4

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- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

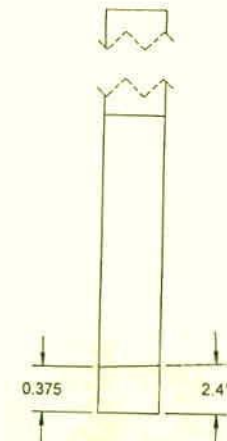
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D3560-1 ARM WELDMENT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

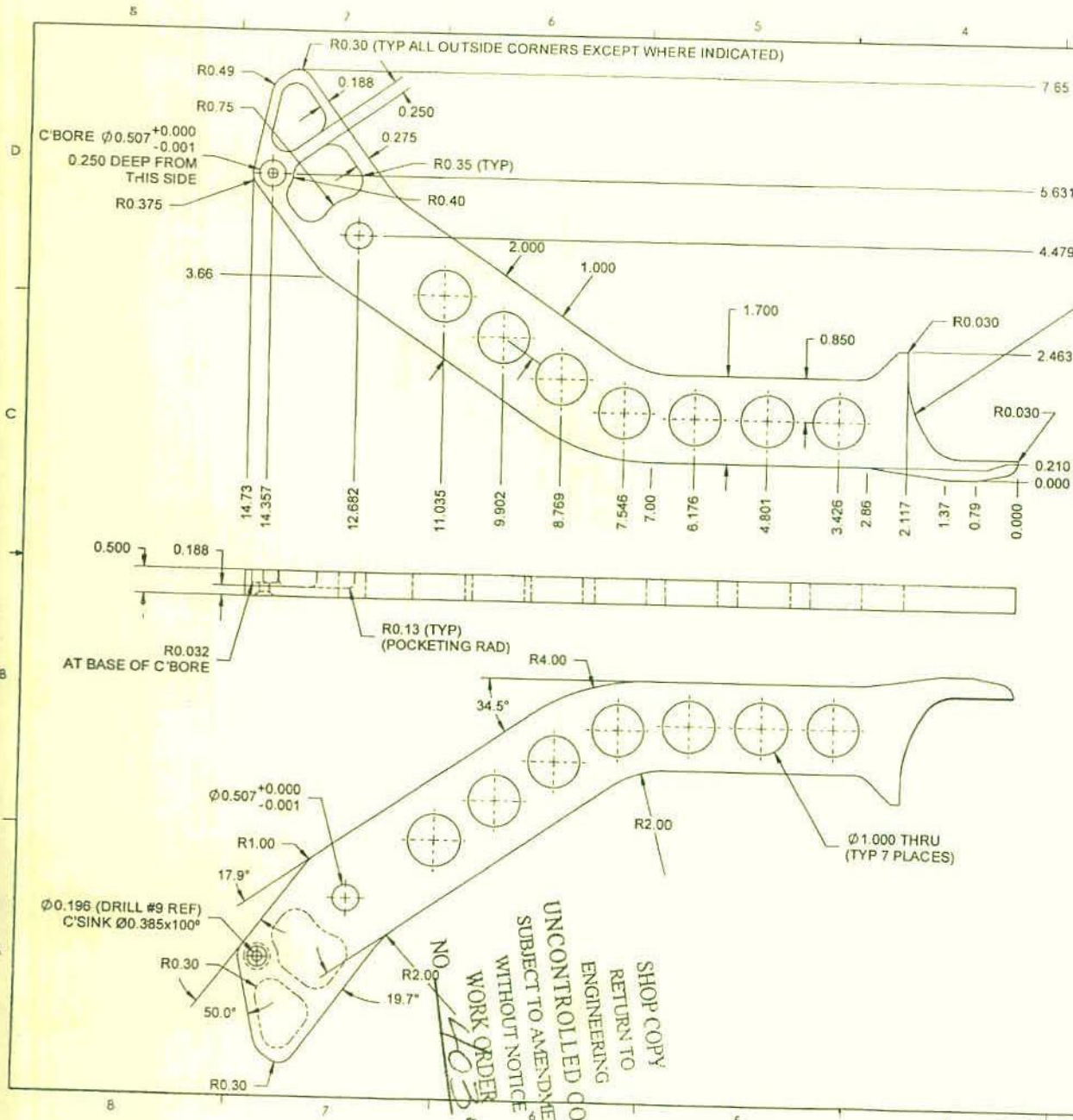


VIEW C-C
SCALE 1:1

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MFG. APPR.	SC	D3560	SHEET 2 OF 5
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DE APPR.	SC	ARM WELDMENT	1:2
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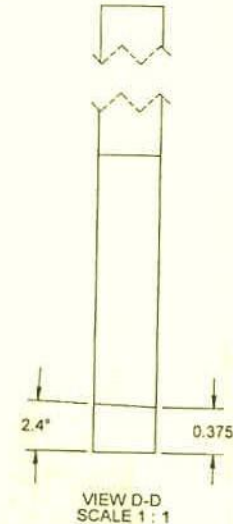


PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4°,
SEE VIEW D-D

D3560-2 ARM

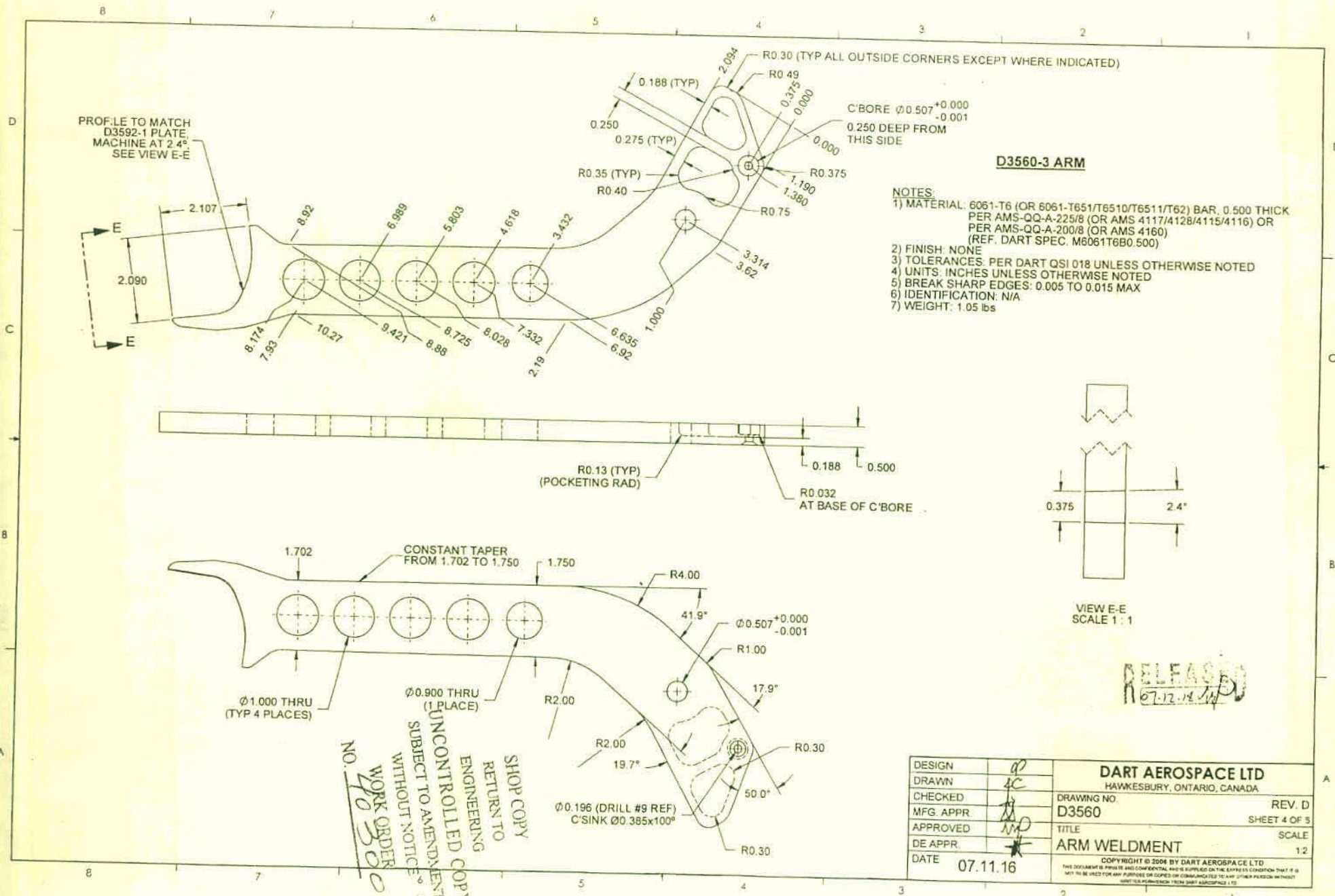
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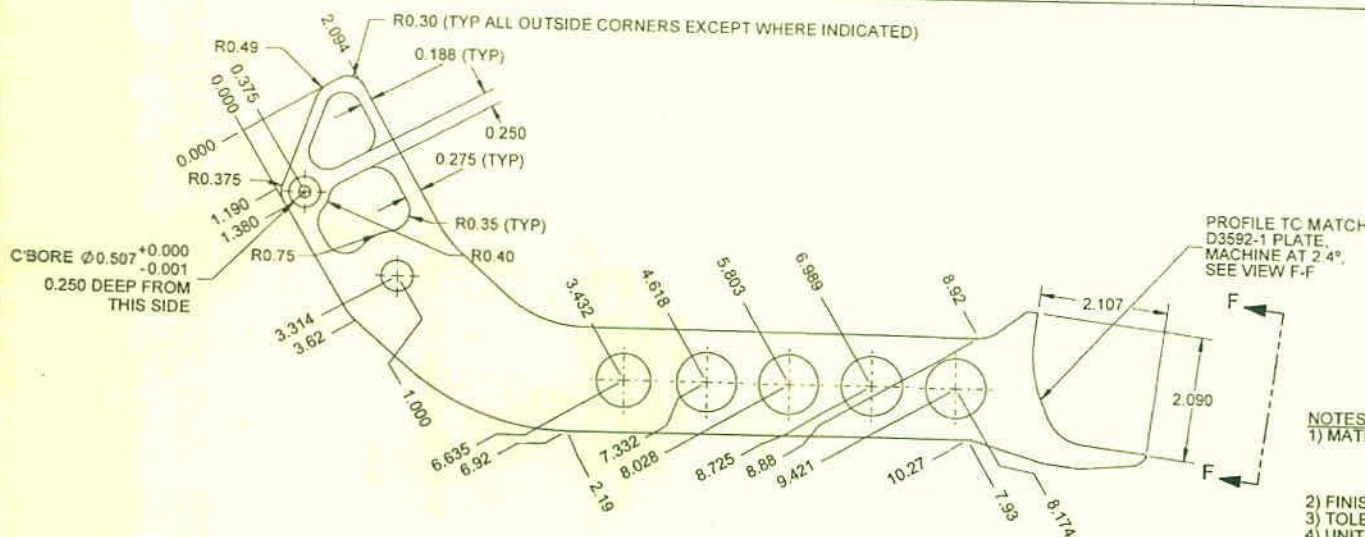
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC: M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



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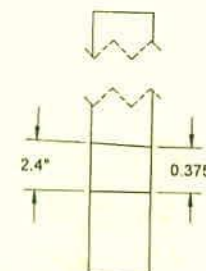
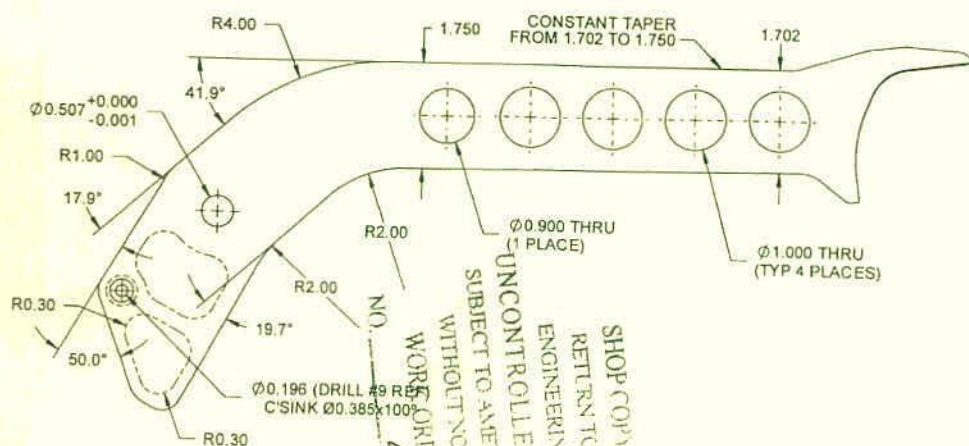
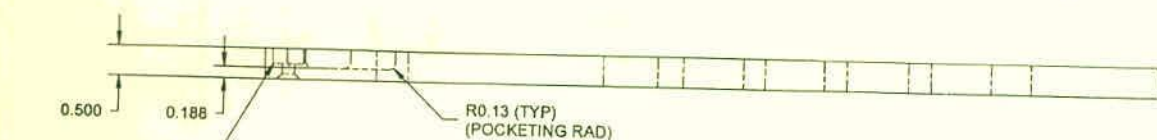
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D3560-4 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1:1

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DE APPR.		ARM WELDMENT	12
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